

DT 8730



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2665-1

Job Sheet 208526



Part No: D2665-1

Job Qty: 12 pcs

Part Name: Saddle, LH Fwd Aft Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/23/20

Job Tracking No:

Due Date: 4/20/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D
07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	4/20/20		1.00	18.46	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	12 pcs	4/20/20		0.00	12.00	Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		
120	QC 2	12 pcs	4/20/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
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Container No: S268794



Part: D2665-1

Job No: 208526

Serial No/Batch: S268794

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/04/20

Plex 3/23/20 8:07 AM Dart.lajeunesse.marie

					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	DTP 20-04-06
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
130	QC 8	12 pcs	4/20/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	ML 20/04/17
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
140	Handfinish - 1-1 Chemical-B4B	12 pcs	4/20/20	0.00 0.85	Handfinish - 1 - 1 - B4B	BE B24-04-17
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	

					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	12 pcs	4/20/20	0.00 0.60	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	12 pcs	4/20/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
170	Packaging 3-1 - Stock - B4B	12 pcs	4/20/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	

M25H469.

START: 8:10 UNT: 3:00 FINISH: 8:40

20-04-20

DAS 34 88

BFB 20-04-21

DAS 59 9-89

DAS 28 9-89

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	12	4/20/20	0.00 0.00	QC 21 - SA - 21	DAS 21
	pcs			QC 21 - SA - 70	9-45
				QC 21 - SA - 53	APR 7 1 2020

Part Op **100** - HAAS CNC Vertical Machine Program batch number. 1- Inspect part number and batch number are programmed
 Descriptions: correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of
 Folio and visually inspect as per attached Dimension Sheet
110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Chemical Conversion Coat per QSI005 4.1
150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
160 - QC3- Inspect Part Finish Standard Process
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	12 pcs (1 ea)	100-HAAS 4 Axis	S240460

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	12	36	0

Part Specifications

Specifications could not be found.

Plex 3/23/20 8:07 AM Dart.lajeunesse.marie

D6101-003
S240460

DART AEROSPACE LTD		Work Order: 208526
Description: 206 Saddle, Outboard, Left side		Part Number: D2665-1
Inspection Dwg: D2665	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.120	0.120	0.121	0.120	0.121
B	0.100	0.140		0.127	0.128	0.1275	0.127	0.128
C	1.125	1.145		1.135	1.135	1.135	1.135	1.135
D	0.615	0.685		0.660	0.660	0.660	0.660	0.660
E	0.240	0.260		0.249	0.248	0.248	0.248	0.249
F	1.313	1.343		1.322	1.323	1.323	1.323	1.323
G	0.210	0.230		0.220	0.221	0.222	0.220	0.221
H	0.100	0.180		0.133	0.133	0.133	0.133	0.133
I	2.470	2.510		2.494	2.494	2.494	2.494	2.494
J	1.565	1.585		1.575	1.575	1.575	1.575	1.575
K	0.235	0.240		0.238	0.238	0.238	0.238	0.2375
L	0.100	0.120		0.116	0.116	0.116	0.116	0.116
M	0.990	1.010		1.005	1.005	1.005	1.005	1.005
N	0.510	0.515		0.511	0.511	0.511	0.511	0.511
O	5.990	6.010		6.002	6.002	6.002	6.002	6.002
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		0.313	0.313	0.313	0.313	0.313
S	0.315	0.322		0.316	0.316	0.316	0.316	0.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		0.797	0.798	0.798	0.797	0.797
W	0.540	0.560		0.551	0.551	0.550	0.551	0.551
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		0.258	0.258	0.258	0.258	0.258
Z	0.912	0.932		0.924	0.923	0.923	0.923	0.922
AA	0.490	0.510		0.5025	0.501	0.500	0.500	0.501
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AC								
AD								
AE								
Accept/Reject								

Measured by: JTD	Date: 20-04-04
Audited by: SML	Date: 20/04/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	M

DART AEROSPACE LTD		Work Order: 208526
Description: 206 Saddle, Outboard, Left side		Part Number: D2665-1
Inspection Dwg: D2665 Rev: D DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	9	10
A	0.100	0.140		0.121	0.121	0.121	0.121	0.121
B	0.100	0.140		0.128	0.128	0.128	0.127	0.127
C	1.125	1.145		1.135	1.135	1.135	1.135	1.135
D	0.615	0.685		0.660	0.660	0.660	0.660	0.660
E	0.240	0.260		0.248	0.248	0.248	0.248	0.248
F	1.313	1.343		1.323	1.323	1.323	1.323	1.323
G	0.210	0.230		0.221	0.222	0.222	0.222	0.222
H	0.100	0.180		0.133	0.133	0.133	0.133	0.133
I	2.470	2.510		2.494	2.494	2.494	2.494	2.494
J	1.565	1.585		1.575	1.575	1.575	1.575	1.575
K	0.235	0.240		0.2375	0.238	0.238	0.238	0.2375
L	0.100	0.120		0.116	0.116	0.116	0.116	0.116
M	0.990	1.010		1.005	1.005	1.005	1.005	1.005
N	0.510	0.515		0.511	0.511	0.511	0.511	0.511
O	5.990	6.010		6.002	6.002	6.002	6.002	6.002
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		0.313	0.313	0.313	0.313	0.313
S	0.315	0.322		0.316	0.316	0.316	0.316	0.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		0.797	0.798	0.798	0.798	0.798
W	0.540	0.560		0.551	0.553	0.552	0.553	0.552
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		0.258	0.258	0.258	0.258	0.258
Z	0.912	0.932		0.922	0.923	0.923	0.923	0.923
AA	0.490	0.510		0.502	0.502	0.503	0.501	0.502
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AC								
AD								
AE								
Accept/Reject								

Measured by: JIP	Date: 20-04-05
Audited by: [Signature]	Date: 20/04/17
Prototype Approval:	Date:

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Inspection Dwg: D2665	Rev: D	Page 1 of 1

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Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	0.100	0.140		0.121	0.122			
B	0.100	0.140		0.128	0.128			
C	1.125	1.145		1.135	1.135			
D	0.615	0.685		0.660	0.660			
E	0.240	0.260		0.248	0.248			
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M	0.990	1.010		1.005	1.005			
N	0.510	0.515		0.511	0.511			
O	5.990	6.010		6.002	6.002			
P	1.245	1.255		1.250	1.250			
Q	2.495	2.505		2.500	2.500			
R	0.312	0.318		0.313	0.313			
S	0.315	0.322		0.316	0.316			
T	2.495	2.505		2.500	2.500			
U	1.357	1.367		1.362	1.362			
V	0.787	0.807		0.798	0.798			
W	0.540	0.560		0.552	0.551			
X	1.674	1.684		1.679	1.679			
Y	0.256	0.262		0.258	0.258			
Z	0.912	0.932		0.923	0.923			
AA	0.490	0.510		0.501	0.502			
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Accept/Reject								

Measured by: DTP	Date: 20-04-05
Audited by: [Signature]	Date: 20/04/17
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G	12.03.08	Dimension R and Y revised	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					